



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W5-5
Job Sheet 185249



Part No: RBE105-14181W5-5

Job Qty: 5 ea

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18 *Dec 2*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W5 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-3		
110	Lathe Conv	5 pcs	11/9/18	11/9/18	0.00	5.00	Lathe Conv-2		
120	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		
130	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		
150	Outsource	5 pcs	11/9/18	11/9/18	0.00	0.00	Outsource4		
160	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		
170	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC6		
180	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		
190	QC21-SA	5 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. 2-Deburr

Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

150 - Issue P/O to GROUPE ALTECH; PO *041768* -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R2.250	6061-T6 Round Bar 2.250"	.6100 ft (.122 ea)	90-Start up Operation	<i>519661</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R2.250	1	14	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ould not be found.

Plex 10/24/18 10:44 AM Dart.lajeunesse.marie

Container No: S127684



Part: RBE105 - 14181W5 - 5

Job No: 185249

Serial No/Batch: S127684

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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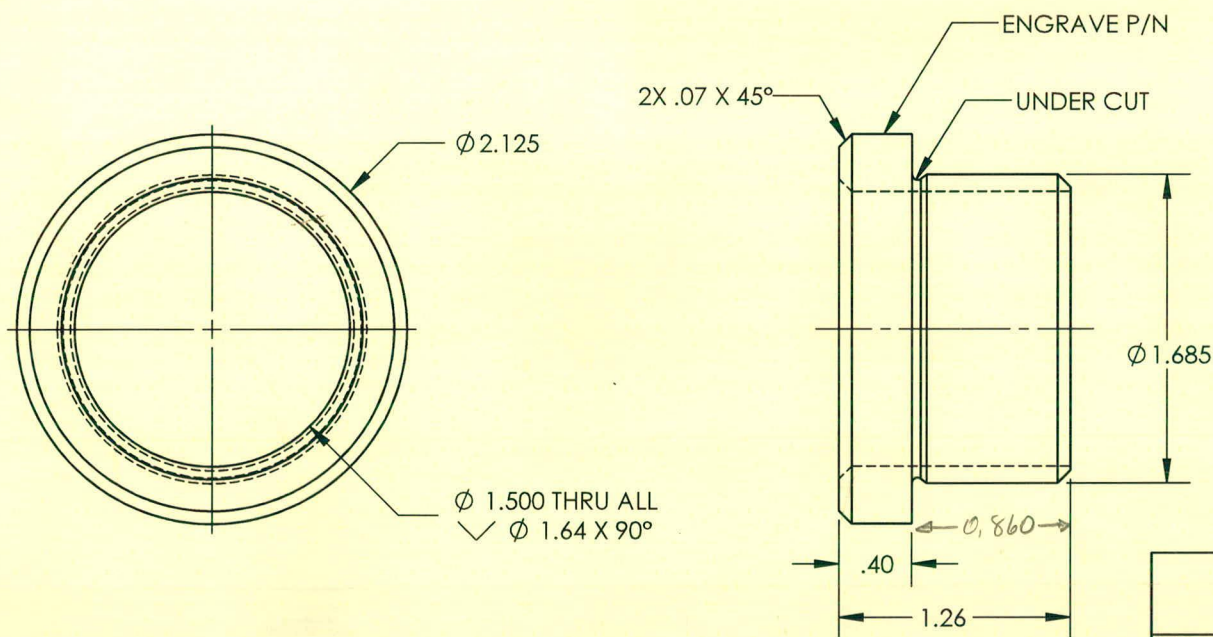
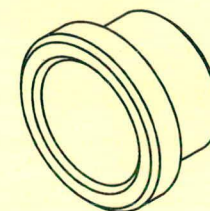
Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185249 MJS
18-10-24



(-5)
GUIDE

DART AEROSPACE	
TITLE PUSHING-OUT TOOL	
DWG NO. RBE105-14181W5-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH CLEAR ANODIZE	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC MIL-A-8625, TYPE II, CLASS I	.X $\pm$.1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 1/13/2016 SHEET 4 OF 7



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041768**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041768
PO Date: 11/19/18
Due Date: 11/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185494	RBE117-80168-W1-3	Rod -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$5.25/pcs	\$26.25
							5 X	NOV 30 2018			
2	185204	RBE105-14101W7	Needle Bearings Drive Tool -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$6.90/pcs	\$34.50
							5 X	NOV 30 2018			



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PURCHASE ORDER **PO041768**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185249	RBE105-14181W5-5	Guide -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$1.65/pcs	\$8.25
						5X NOV 30 2018					
4	185253	RBE105-14181W6-5	Guide Bushing -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$1.30/pcs	\$6.50
						5X NOV 30 2018					
5	185243	RBE105-14181W2-3	Press -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$2.45/pcs	\$12.25
						5X NOV 30 2018					
6	185250	RBE105-14181W5-7	Support -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$4.85/pcs	\$24.25
						5X NOV 30 2018					

DAS
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PURCHASE ORDER **PO041768**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	185254	RBE105-14181W6-7	Support -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/18	5 pcs	0 pcs	5 pcs	\$3.85/pcs	\$19.25
Grand Total:											\$131.25

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/26/18 2:42 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014598-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014598- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
30-Nov-2018		Jessie Boisvert		041768				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE117-80168-W1-3 Rev.	RBE117-80168-W1-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
2	RBE105-14101W7 Rev.	RBE105-14101W7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
3	RBE105-14181W5-5 Rev.	RBE105-14181W5-5 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
4	RBE105-14181W6-5 Rev.	RBE105-14181W6-5 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
5	RBE105-14181W2-3 Rev.	RBE105-14181W2-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
6	RBE105-14181W5-7 Rev.	RBE105-14181W5-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0
7	RBE105-14181W6-7 Rev.	RBE105-14181W6-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

